

Work Order ID 51610

August 27, 2009 8:26:44 AM

Page 1

Item ID: D3791-1 *GY*

Accept

Revision ID: A

Item Name: Wearplate

Start Date: 8/27/09

Start Qty: 12.00

Required Date: 9/11/09

Req'd Qty: 12.00

Reference:

Approvals:

Process Plan: *RL-mt*

Date: *09-8-27*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3791

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3791

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-9-09

(12)

B 9-9-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

12

08.05.25

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

SB 09/09/30

12

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

SB 09/09/30

12

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

Large Fab

Memo

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M109893

0.00

0.00

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Cust Item ID:

Customer:

EL 9-10-7 (X12)

(X12) /

(X12) /

W/O:		WORK ORDER CHANGES					
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Stop

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Start Qty: 12.00

Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00

OVEN TEMPERATURE: 320°

FINISH TIME: 11:30

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: FP-17

0.00



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Setup Start



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Item Name: Wearplate

Stop



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Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

W 9.10.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

August 27, 2009 8:26:44 AM

Page 1

Work Order ID: 51610

Parent Item: D3791-1RevA

Parent Item Name: Wearplate

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	150.0498	3.6846			



304/316 Sheet .063



LB 9-4-09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

150.0497737

106860

16.018

111924

33.0549737

112290

100.9768

112567

112567

112567

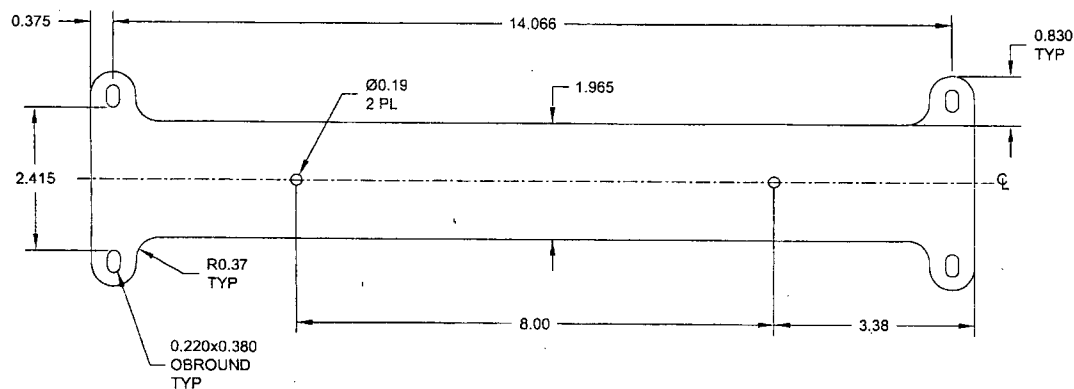
W/O:		WORK ORDER CHANGES					
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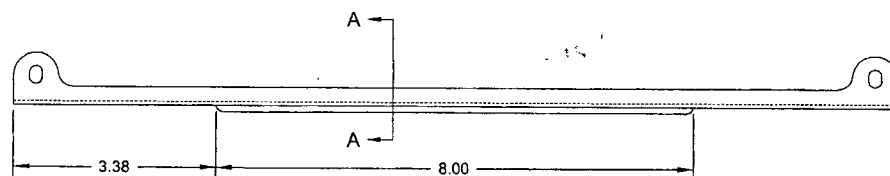
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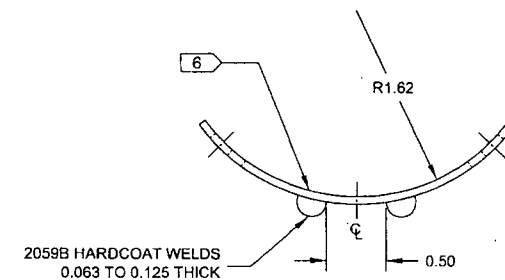
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 57610

RELEASED
 08-05-24-118

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A NEW ISSUE		PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.13		

DART AEROSPACE USA, INC		REV. A
PORT HADLOCK, WA		SHEET 1 OF 1
DRAWING NO.	D3791	SCALE
TITLE	WEARPLATE	NTS

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